

Date: Tuesday, 11/22/2005 10:05:56 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STEM
Job Number : 24888	
Estimate Number : 10857	
P.O. Number : N/A	Part Number : D34073
This Issue : 11/22/2005 S.O. No. : N/A	Drawing Number : D3407 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : C
Previous Run : N/A	Material : N/A
Written By : <u>See comment below</u>	Due Date : 12/15/2005 Qty: 10 Um: Each
Checked & Approved By : <u>See comment below</u>	
Comment : Est Rev:A 05.10.18 New issue KJ/EC	

Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description :

1.0

M174R0750

Inventory



Comment: Qty.: 0.3843 f(s)/Unit Total : 3.8430 f(s)
 Material: 17-4ph SS Round Bar Ø0.750(M17-4-R0.750)
 Identify for D3407-3
 Batch: M18742

ML 05/11/28 10

PTO

2.0

HARDINGE

HARDINGE CNC LATHE SMALL

**Comment:** HARDINGE CNC LATHE SMALL1-Turn as per Folio FA597 Rev: A & Dwg D3407 Rev: C

2-Deburr

ML 05/12/01 10

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

ML 05/12/01 10

4.0

HAAS1

HAAS CNC VERTICAL MACHINING #1

**Comment:** HAAS CNC VERTICAL MACHINING #1

1- Machine as per Folio FA597 and Dwg D3407

2-Deburr

ML 05/12/06 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 05/12/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
05/12/01	2	1 piece scrap program was wrong 1 piece scrap the offset was wrong.	<i>AB</i> 05/12/01	2 parts scrap, destroy & replace. Adjust program i	<i>ml</i> 05/1	<i>2</i> 05-12-01	<i>AB</i> 05/12/01	<i>2</i> 05-12-01

NOTE: Date & initial all entries

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User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEM

Job Number: 24888

Part Number: D34073

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MB 05/12/06

10

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

ML 05/12/06

10

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 423

10 05/12/06

10

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

545 05/12/07

(10)

17 05/12/07 (10)

Job Completion



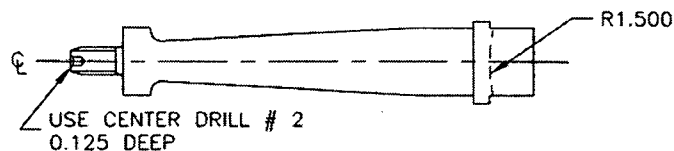
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

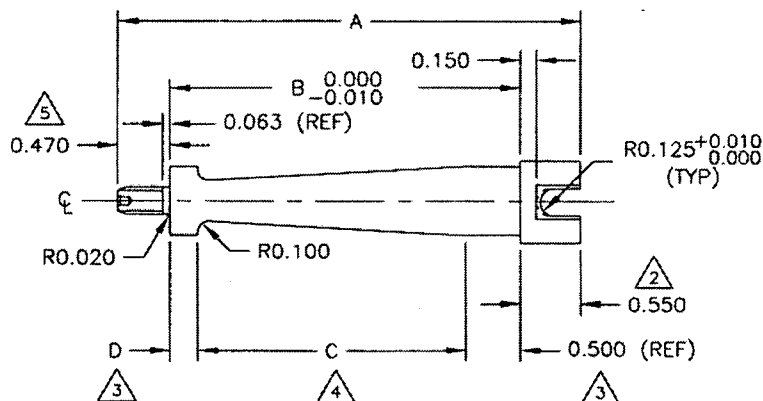
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED

05.09.12



PART NUMBER	A	B	C	D
D3407-1	5.270	4.250	3.250	0.500
D3407-3	4.325	3.305	2.555	0.250

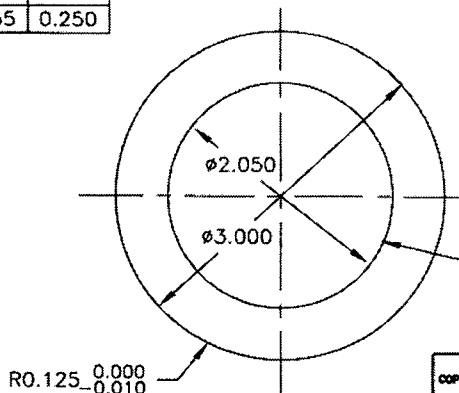
D3407-1/-3 STEM

D3407-1 AND D3407-3 STEM:

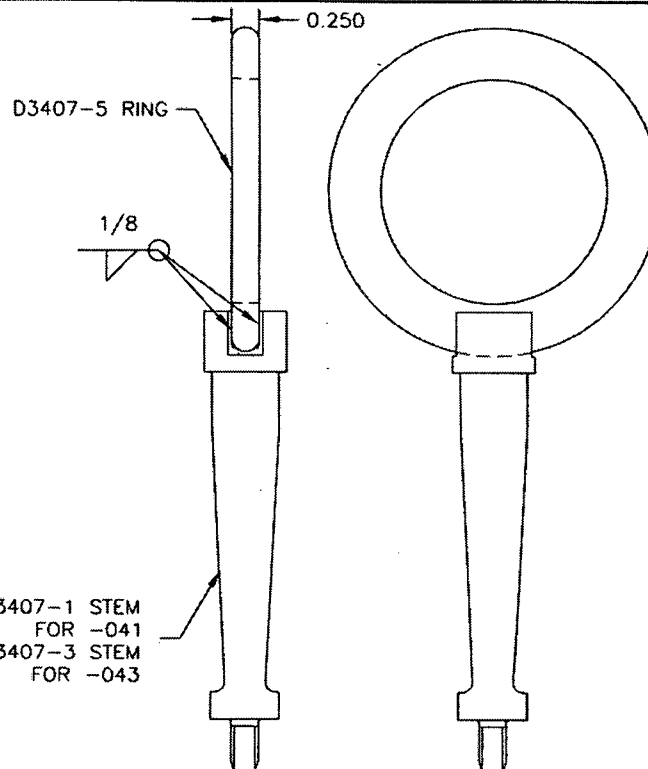
- 1) MATERIAL: 17-4 PH SS ROUND BAR (REF DART SPEC. M17-4-R0.750)
- 2) $\phi 0.750$ O.D.
- 3) $\phi 0.625$ O.D.
- 4) MACHINE UNIFORM TAPER FROM $\phi 0.363$ O.D. TO $\phi 0.625$ O.D.
- 5) 1/4-28 UNF THREAD WITH 0.063 GRIP, CLASS 2A
- 6) MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
- 7) UNLESS OTHERWISE INDICATED
- 8) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D3407-5 RING:

- 9) MATERIAL 17-4 PH SS ROUND BAR (REF DART SPEC. M17-4-R3.000)
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D3407-5 RING



D3407-041 AND D3407-043 TOW RING:

- 11) WELD PER QSI 004 ON ALL EDGES BETWEEN STEM AND RING
- 12) FINISH: POWDER COAT WHITE (REF 4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
- 14) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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C	05.09.09	-1/-3 LONGER FOR FIT W/ WASHER
B	05.06.17	UPDATE DIAMETER, THREAD CLASS ADDED
A	05.03.16	NEW ISSUE
DESIGN	CP	DART AEROSPACE USA, INC.
CHECKED	CP	DART AEROSPACE USA, INC.
APPROVED	CP	DART AEROSPACE USA, INC.
DRAWING NO.	D3407	REV. 0
DATE	05.09.09	SHEET 1 OF 1
TITLE	TOW RING	SCALE 1:1

□□□□□□□□

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 18, 2005
09:21 am

Work Order No	:	0024888	Department Code:	
Project Name	:	D3407-3	Burden Flags	: NNNNNNNN
Project For	:	WK549	WO Status	: Open
Work Order Type	:	Main	Invoice State	: Not Invoiced
Main WO Number	:		Invoice Date	:
House Part Number	:	D3407-3	Invoice Number	:
Description	:	Stem	Invoice Amount	: 0.00
Manufactured	:	Yes		
Amount Req'd	:	10	Order Entry No	:
Amount Done	:	0	OE Value	: 0.00
Start Date	:	11-18-05		
Est Finish Date	:	12-15-05	Est Margin	: 0.000%
Act Finish Date	:		Actual Margin	: 0.000%
Drawings Req'd	:	No		
Ok for Approval	:			
Approval Rec'd	:		\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
=====	=====	=====	=====	=====	=====
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
=====	=====	=====	=====		
Burden :	0.00	0.00	0.00		
=====	=====	=====	=====		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

DART AEROSPACE LTD		Work Order: 24888
Description: Stem		Part Number: D3407-3
Inspection Dwg: D3407 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.325	$\pm .010$	4.327	✓			
3.305	$\pm .000$ $\pm .010$	3.302	✓			
2.555	$\pm .010$	2.545	—			
0.250	$\pm .010$	0.253	—			
0.470	$\pm .010$	0.470	✓			
0.063	$\pm .010$	0.070	—			
0.500	$\pm .010$	0.510	✓			
Ø0.750	$\pm .010$	Ø0.248	—			
Ø0.625	$\pm .010$	Ø0.623	✓			
Ø0.625	$\pm .010$	Ø0.621	✓			
Ø0.363	$\pm .010$	Ø0.362	—			
0.550	$\pm .010$	0.548	✓			
0.150	$\pm .010$.155	✓			
0.250	$\pm .010$ $\pm .000$.252	✓			
0.625	$\pm .010$.628	✓			
1/4-28 Majorda	0.243-0.249	0.2445	✓			
HOW	0.261-0.267	0.266	—			

Measured by: JML	Audited by: J.L	Prototype Approval:
Date: 05/12/01	Date: 05.12.01	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	